

# Work Order ID 81178

**\*81178\***

Page 1

March-12-12 8:39:01 AM

Item ID: D4018-5

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib

Start Date: 09/03/2012 Start Qty: 6.00

**\*6\***  
**\*6\*** 54x

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4018

C

100

0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4018  
2- debur and remove identification markings

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: WA

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

*CP 12.06.01* **54x**  $\emptyset$

**(54x)** *WA 12.06.01*

*CP 12.06.01* **54x**  $\emptyset$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81178****\*81178\***

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March-12-12 8:39:01 AM

Item ID: D4018-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Rib

Stop

**\*NS2\***

Start Date: 09/03/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/6/4 JH  
MLJ 12/06/01

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**NOTE:** Date & initial all entries

# Picklist Print

March-12-12 8:39:05 AM

Page 1

Work Order ID: 81178

\*81178\*

Parent Item: D4018-5

\*D4018-5\*

Parent Item Name: Rib

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
RevB DD 10.04.16 verified by:EC  
10.08.18 verified by:EC  
IPP Rev:B as  
IPP Rev:C as per dwg  
IPP Rev:D as per dwg revC DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

348.2521

0.5558

~~3.510316~~

31.5928

\*M304TS0 500W 049\*

Square Tubing

\*\*

R12.06.01

Location

Loc Qty

Loc Code

MAT034

348.2520653

116610

0.8383

117721

0.3234

117999

2.43919739

118460

344.651168

M121328 → 31.5928

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

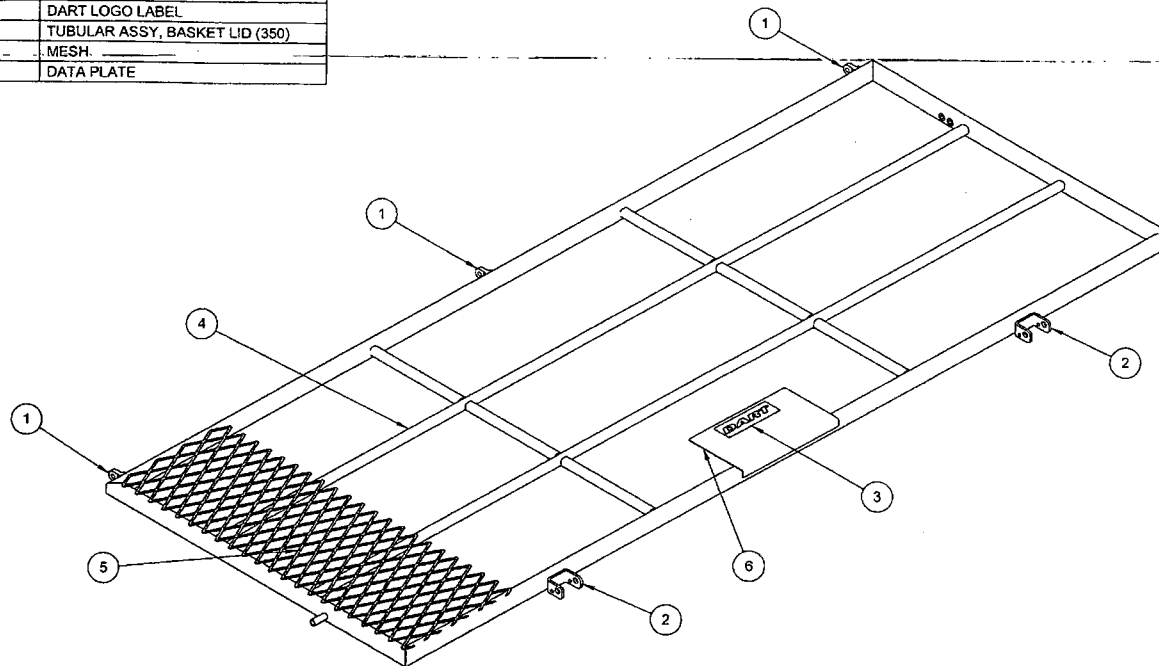
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81178 MJS  
12/03/12

RELEASED  
10.08.12  
ECN 10-596

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AKS		
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4018** REV. C  
SHEET 1 OF 4  
TITLE **SHORT BASKET LID ASSY (350)** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

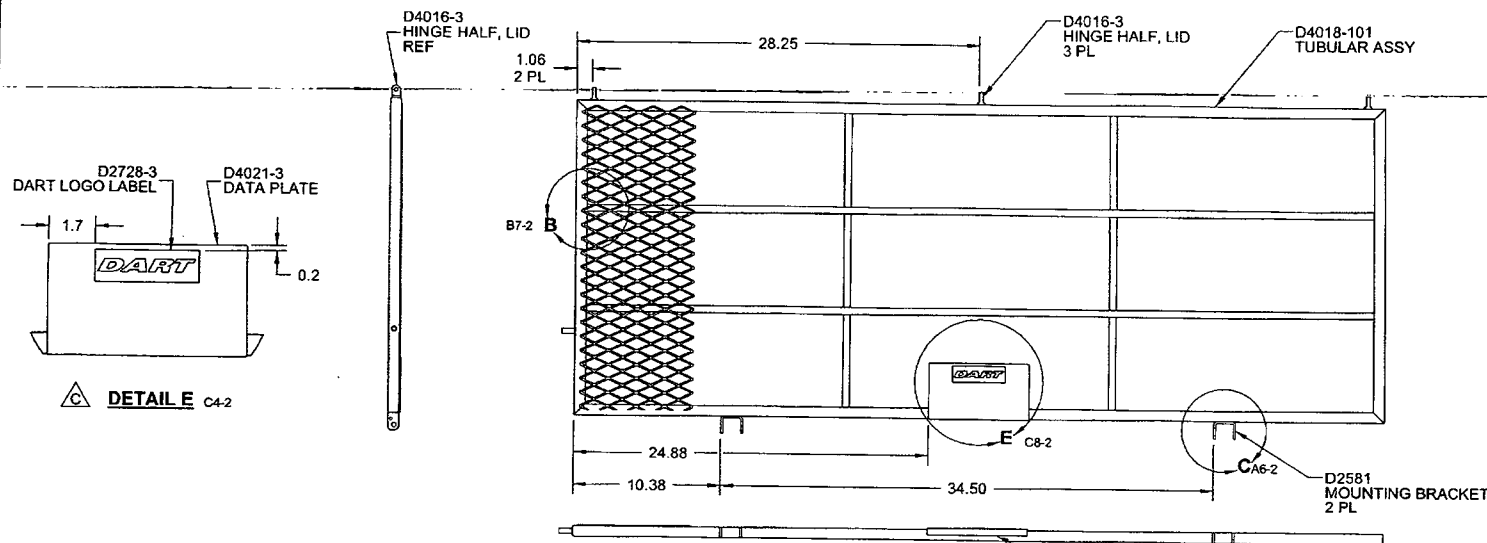
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

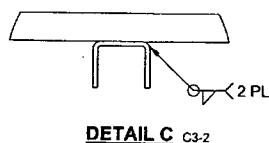
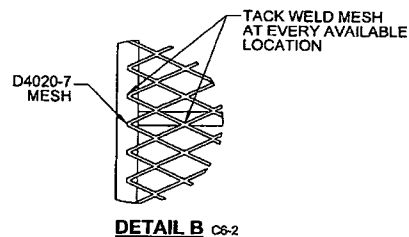


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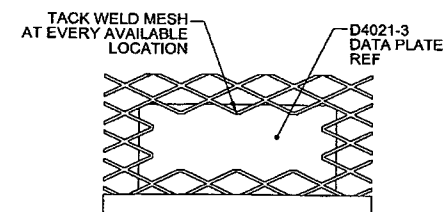
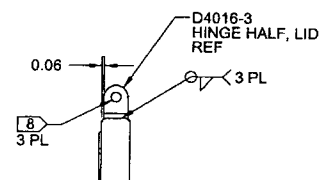
RELEASED  
10 08 12



**DETAIL E** C4-2



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**VIEW A-A** C1-2

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

**DETAIL D** D1-2

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	<b>D4018</b>	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	<b>SHORT BASKET LID ASSY (350) NTS</b>	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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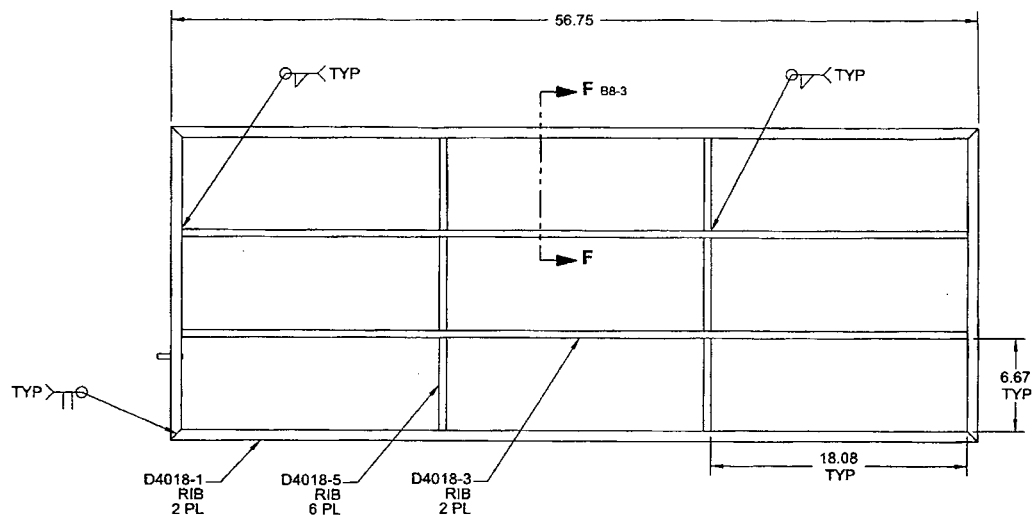
**NOTE:** Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



D4035-041  
RIB ASSY, FWD

**SECTION F-F C3-3**



**D4018-101 TUBULAR ASSY, BASKET LID (350)**

**RELEASED**  
10.08.12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. <b>D4018</b>	REV. C
MFG. APPR.	JS	SHEET 3 OF 4	
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>SHORT BASKET LID ASSY (350)</b>	
DATE	10.08.05	NTS	

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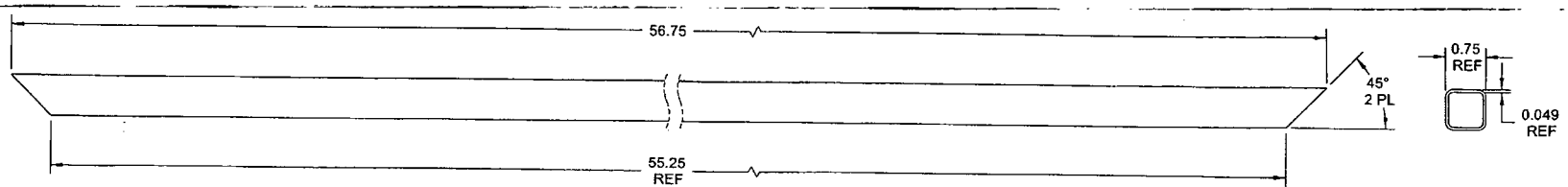
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

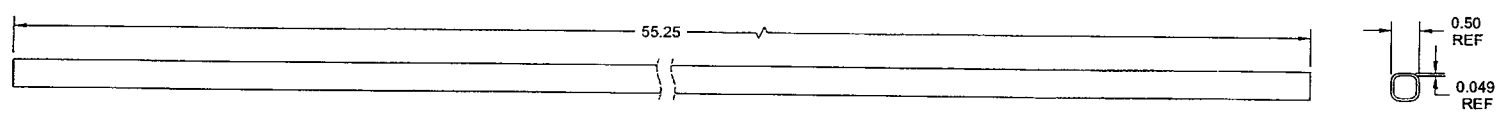
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**NOTE:** Date & initial all entries

81178



**D4018-1 RIB**



**D4018-3 RIB**



**D4018-5 RIB**

**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
18.08.12 UP

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JSC	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
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